

Job Set #38



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4464-041**Job Sheet 174297****Part No:** D4464-041**Job Qty:** 1 ea**Part Name:** Fuel Tank Assembly**Part Weight:** 0 lbs**Status:** Scheduled**Priority:** Medium**Job Created:** 3/13/18**Job Tracking No:****Due Date:** 4/20/18**Created By:** Michelle Gagnon-Donovan**Type:** SOLD**Description:**

Note: DWG REV H IPP REV:A 11.11.23 NEW ISSUE DD VERF:EC IPP REV:B 12.03.08 AS PER DWG REV.B DD
VERF:EC IPP REV:C 12.04.24 ECN 12-571 DD VERF:EC IPP REV:D 13.10.30 DWG REV PE1 DD
VERF:JLM IPP REV:E 14.06.13 AS PER DWG REV.E DD VERF:JLM IPP REV:F 14.07.21 AS PER DWG
REV.F DD VERF:JLM IPP REV:G 15.01.15 AS PER DWG REV.G DD VERF:JLM IPP REV:H 15.03.04 AS
PER DWG REV.H9 DD VERF:JLM IPP REV:I 15.06-17 AS PER DWG REV.H DD VERF:JLM

Ship Via:**Bill of Materials**

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S068339**Part:** D4464-041**Job No:** 174297**Serial No/Batch:** S068339**Revision:** I**Inspector:****Date:** 05/03/18

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		4/11/18	0.00	0.00	Start Up Large Fab-7		D.M.L 18-5-2
100	Large Fab	1 pcs		4/12/18	0.00	10.34	Large Fab 2		CPC
110	QC	1 pcs		4/12/18	0.00	0.00	QC9		
112	Small Fab	1 pcs		4/12/18	0.17	1.53	Small Fab-6		SP
114	QC	1 pcs		4/12/18	0.00	0.00	QC5		CPC
120	Large Fab	1 pcs		4/12/18	0.00	10.34	Large Fab 2		CPC
123	Small Fab	1 pcs		4/12/18	0.00	1.53	Small Fab-6		SP
140	Large Fab	1 pcs		4/13/18	0.00	10.34	Large Fab 2		CPC
141	QC	1 pcs		4/13/18	0.00	0.00	QC9		10 16-05-04
142	QC	1 pcs		4/13/18	0.00	0.00	QC5		10 18-05-04
143	Outsource	1 pcs		4/19/18			SKY002-VC	5	AT 18/05/10
145	Packaging	1 pcs		4/19/18	0.00	0.00	Packaging2		AT 18/05/16
147	QC	1 pcs		4/19/18	0.00	0.00	QC6		8-3
150	HandFinish	1 pcs		4/19/18	0.00	1.32	HandFinish1		SA 18-05-10
160	QC	1 pcs		4/19/18	0.00	0.00	QC7-3		SP
164	Small Fab	1 pcs		4/19/18	0.00	1.53	Small Fab-6		DAS
169	QC	1 pcs		4/19/18	0.00	0.00	QC5		38
170	SprayPaint	1 pcs		4/19/18	0.00	1.73	Spray Paint		18 MAY 9-89
180	QC	1 pcs		4/19/18	0.00	0.00	QC14		38
190	Small Fab	1 pcs		4/20/18	0.00	1.53	Small Fab-6		9-89 DAS
200	QC	1 pcs		4/20/18	0.00	0.00	QC5		38
210	Packaging	1 pcs		4/20/18	0.00	0.00	Packaging3-2		9-89
220	QC21-SA	1 Ea		4/20/18	0.00	0.00	QC21		DAS MAY 3 1 2018

Part Op 100 - 1- Weld D4023-3 cap as per dwg D4464 2- Buff alodine on all edges welded parts.

Descriptions: 112 - 1- Wet install baffles to front and back panel using rivet and Proseal as per dwg A/R Proseal

Batch: 138784

120 - 1- Use fixture to weld D4125 bolts to D4463-13 as per dwg. 2- Tack Weld D4463-3 to side, front a back panel.

123 - Transfer drill and c'sink D4975-1 bracket to bottom bracket, wet install as per dwg Proseal 890B

Batch: 138784 Install hinge wet with proseal as per dwg A/R Proseal 890B Batch: 138784 Install D4000-9 grommets as per dwg, ***D4000-1 FLAT SURFACE MUST BE INSTALL UPWARDS AS PER DWG*** Install fitting D4000-1 wet with proseal as per dwg A/R Proseal 890B Batch: 138784

140 - Weld top D4463-1 using DT9811 and DT9810 Finish welding the rest of the tank.

143 - ISSUE P/O: 39812 LIQUID PENETRANT INSPECTION AS PER QSI 0890R LPI AS PER ASTM 1417 LEVEL 2

MAY 09 2018

150 - 1- Alodine on tank. No alodine inside

164 - 1- Brush Proseal 890A on all internal sheet metal folds Proseal 8990A Batch: 138784 2- Assemble as per dwg and for D4577-041/-3/-5 access panels install wet with proseal 890B A/R Proseal 890B Batch: 138784

170 - ***MASK PROIOR PRIME AND PAINT AS PER DWG*** PRIME TEMPO GREY AS PER DWG AND QSI PRIMER BATCH: 138784 PAINT FLAT GREY AS PER DWG AND QSI PAINT BATCH: 138819

190 - 1- Install placards, fuel sender, tank support, fuel filler splash guard assy, fuel cap as per dwg 2- Abrade surface with red scotch brite and install cushion using contact cement A/R Contact Cement Batch: 138784

1300L

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3999-7	Corner	1 Ea (1 ea)	90-Start up Operation	F156521
D4000-5	Fuel Tank Vent Fitting	1 Ea (1 ea)	90-Start up Operation	F158936 F107388
D4023-3	Cap And Flange	1 Ea (1 ea)	90-Start up Operation	F160125
D4125-1	Fwd Sediment Bowl	1 Ea (1 ea)	90-Start up Operation	F156449
D4125-3	Aft Sediment Bowl	1 Ea (1 ea)	90-Start up Operation	F156459
D4462-1	Baffle	1 Ea (1 ea)	90-Start up Operation	F5025826
D4462-3	Baffle	1 Ea (1 ea)	90-Start up Operation	F160611
D4463-041	Tank Top Assembly	1 Ea (1 ea)	90-Start up Operation	F160611 F50527 63
D4463-11	Tank Front	1 Ea (1 ea)	90-Start up Operation	F163009
D4463-13	Tank Bottom	1 Ea (1 ea)	90-Start up Operation	F5006588
D4463-3	Tank Aft End	1 Ea (1 ea)	90-Start up Operation	F163531
D4463-5	Tank Upper Cut Out	1 Ea (1 ea)	90-Start up Operation	S052484
D4463-7	Tank Fwd End	1 Ea (1 ea)	90-Start up Operation	F160612 → 2
D4463-9	Tank Back	1 Ea (1 ea)	90-Start up Operation	S026899
AN3-5A	Bolt	24 Ea (24 ea)	190-Small Fab	S041106-1
AN3-7A	Bolt	4 Ea (4 ea)	190-Small Fab	F1613764-1
AN3H5A	Bolt	5 Ea (5 ea)	190-Small Fab	137521
D3997-11	Placard	1 Ea (1 ea)	190-Small Fab	F160132
D3997-17	Placard	1 Ea (1 ea)	190-Small Fab	F157362
D3997-29	Placard	1 Ea (1 ea)	190-Small Fab	F160134
D3997-43	Placard	1 Ea (1 ea)	190-Small Fab	S024106
D3997-5	Placard	2 Ea (2 ea)	190-Small Fab	F162549
D4000-045	Fuel Pickup Fitting Assembly	1 Ea (1 ea)	190-Small Fab	F160585
D4000-1	Fuel Supply Fitting	1 Ea (1 ea)	190-Small Fab	F161003-2
D4000-9	Grommet	3 Ea (3 ea)	190-Small Fab	F152269
D4008-041	Fuel Filler Splash Guard Assembly	1 Ea (1 ea)	190-Small Fab	S058256
D4008-11	Hinge Half	1 Ea (1 ea)	190-Small Fab	F156452
D4057-1	Retaining Ring	3 Ea (3 ea)	190-Small Fab	F156450
D4062-041	Tank Support Assembly	1 Ea (1 ea)	190-Small Fab	F159849
D4404-5	Cushion, Fwd	2 Ea (2 ea)	190-Small Fab	S057465
D4577-041	Fwd Access Panel Assembly	1 Ea (1 ea)	190-Small Fab	F163382
D4577-1	Rear Access Panel	1 Ea (1 ea)	190-Small Fab	F162023
D4577-3	Middle Access Panel	1 Ea (1 ea)	190-Small Fab	F161869
D4968-1	Side Cushion	1 Ea (1 ea)	190-Small Fab	F162023
D4975-1	Bracket	1 Ea (1 ea)	190-Small Fab	F163687
MS20426AD4-4	Rivet	4 Ea (4 ea)	190-Small Fab	F125445-4
MS20470AD4-4	Rivet, Universal Head	165 Ea (165 ea)	190-Small Fab	S027554
MS20470AD4-6	Rivet, Universal Head	8 Ea (8 ea)	190-Small Fab	F1413077-50
MS21042L3	Nut	4 Ea (4 ea)	190-Small Fab	S054107
NAS1149D0332J	Washer	13 Ea (13 ea)	190-Small Fab	S05396
NAS1149D0363J	Washer	24 Ea (24 ea)	190-Small Fab	S015269
D5473-063	Fuel Sender Assembly	1 (1 ea)	190-Small Fab	S075095

NAS1149D0363 1

12

134502.2

Master Unit 002973



Job No 174297

002973

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3999-7	1	3	0
	D4000-5	1	10	0
	D4023-3	1	4	0
	D4125-1	1	4	0
	D4125-3	1	4	0
	D4462-1	1	2	0
	D4462-3	1	1	0
	D4463-041	1	0	0
	D4463-11	1	5	0
	D4463-13	1	3	0
	D4463-3	1	1	0
	D4463-5	1	0	0
	D4463-7	1	2	0
	D4463-9	1	2	0
190-Small Fab	AN3-5A	24	452	0
	AN3-7A	4	64	0
	AN3H5A	5	32	0
	D3997-11	1	3	0
	D3997-17	1	2	0
	D3997-29	1	3	0
	D3997-43	1	4	0
	D3997-5	2	6	0
	D4000-045	1	6	0
	D4000-1	1	6	0
	D4000-9	3	6	0
	D4008-041	1	1	0
	D4008-11	1	1	0
	D4057-1	3	37	0
	D4062-041	1	3	0
	D4404-5	2	0	0
	D4577-041	1	2	0
	D4577-1	1	3	0
	D4577-3	1	2	0
	D4968-1	1	1	0
	D4975-1	1	2	0
	D5473-063	1	0	0
	MS20426AD4-4	4	1,627	0
	MS20470AD4-4	165	3,240	0
	MS20470AD4-6	8	4,595	0
	MS21042L3	4	3,108	0
	NAS1149D0332J	13	3,592	0
	NAS1149D0363J	24	3,263	0
Part Specifications				
Specifications could not be found.				

Plex 3/13/18 1:42 PM Dart.Gagnon.Michelle



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO039812**

Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

PO No: PO039812
PO Date: 5/7/18
Due Date: 5/10/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Lavoie, Chantal
clavoie@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 30

Freight Terms:
Special Comments:

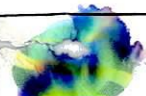
Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	174297	D4464-041	Fuel Tank Assembly ISSUE P/O : LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417 LEVEL 2	Firmed	5/10/18	1 pcs	0 pcs ✓ 1x	1 pcs	\$234.00/pcs	\$234.00
2	176652	D212-664-101	Fwd Crosstube - High *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order.	Firmed	5/10/18	1 pcs	0 pcs ✓ 1x	1 pcs	\$224.00/pcs	\$224.00
	176653			Firmed	5/10/18	1 pcs	0 pcs ✓ 1x	1 pcs	\$224.00/pcs	\$224.00
	176654			Firmed	5/10/18	1 pcs	0 pcs ✓ 1x	1 pcs	\$224.00/pcs	\$224.00
	176655			Firmed	5/10/18	1 pcs	0 pcs ✓ 1x	1 pcs	\$224.00/pcs	\$224.00
Sub Total:						4	0	4		\$896.00

3	176291	SWA6A-2-OH	Electric Swivel 6,000 lb Safe Work Load (2,721 kg)	Firmed	5/10/18	1 pcs	0 pcs ✓ 1x	1 pcs	\$89.00/pcs	\$89.00
4	176051	SWA15A-3-OH	Electric Swivel 15,000 lb Safe Work Load (6,818 kg)	Firmed	5/10/18	1 pcs	0 pcs ✓ 1x	1 pcs	\$89.00/pcs	\$89.00
5	176050	SWA15A-3-OH	Electric Swivel 15,000 lb Safe Work Load (6,818 kg)	Firmed	5/10/18	1 pcs	0 pcs ✓ 1x	1 pcs	\$89.00/pcs	\$89.00
6	176762	SWA6A-4-OH	Electric Swivel 6,000 lb Safe Work Load (2,721 kg)	Firmed	5/10/18	1 pcs	0 pcs ✓ 1x	1 pcs	\$89.00/pcs	\$89.00

Grand Total: \$1,486.00

Order Notes *reid AT 18/05/18*

**skyservice****Work Order Traveler**
Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO35923	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: PO039812
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT ON:

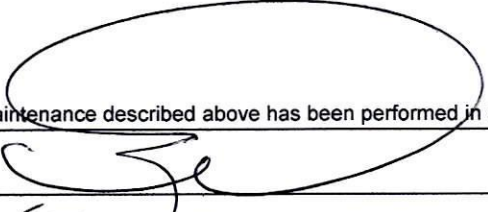
1 FUEL TANK ASSY P/N# D4464-041 , J/S# 174297

4 FWD CROSSTUBES , P/N# D212-664-101 , J/S# 176652 , 176653 , 176654 , 176655

Action Taken:						Date:	Initial/Stamp:
LPI C/O IAW ASTM E-1417M-13						MAY 07 2018	 
NO CRACK FOUND							
PEN. ZL-56, MPO13600, CLEANER SKC-S MPO13923 , DEV. MPO11715 , UV LIGHT M-20142							
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	

DAS
38
9-89

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature: 	ACA/SCA Stamp	Date:
Name: RAFIK MELIKIAN		MAY 07 2018